

Date: Monday, 18/08/2008 4:04:03 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|--------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SWING ARM |
| Job Number | : 41352 | | |
| Estimate Number | : 11303 | | |
| P.O. Number | : | Part Number | : D34479 |
| This Issue | : 18/08/2008 S.O. No. : | Drawing Number | : D3447 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 18/08/2008 Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 41278 | Material | : |
| Written By | : | Due Date | : 18/09/2008 |
| Checked & Approved By | : <u>JUL 08.8.18</u> | Qty: | 30 Um: Each |
| Comment | : Est A 05.08.26 New issue KJ/JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------------|---------------------------|
| 1.0 | M7075T6B1500X1500 | 7075 T6 BAR 1.500 x 1.500 |
|-----|-------------------|---------------------------|



Comment: Qty.: 0.7350 f(s)/Unit Total: 22.0500 f(s)
 7075 T6 BAR
 Material: 7075-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M7075T6B1.500x01.500)
 Identify for D3447-9
 Batch: M18147

(30)

N.A 08/08/21

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



(30)

Comment: BAND SAW
 Cut blanks: 1.500" x 1.500" x 8.400" long

N.A 08/08/21

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



(30)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA544 and Dwg B67-43001
 Identify as D3447-9Dwg Rev A Folio Rev A
 Deburr

N.A 08/08/26

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/08/26

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



(30)

Comment: SECOND CHECK

OK 08/08/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:04:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWING ARM

Job Number: 41352

Part Number: D34479

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature

08/08/28

(X30)

| | | |
|-----|----------------|----------------|
| 7.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



M1102316



(30X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside holes as per Dwg D3447 prior to painting

START TIME:

2:15

OVEN TEMPERATURE:

320

FINISH TIME:

2:45

Handwritten signature

08/08/28

| | | |
|-----|-----|---|
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature

08/08/28

(30)

| | | |
|-----|-------------|-----------------------|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Handwritten signature

08/08/28

(V30)

SD

| | | |
|------|------|------------------------------|
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

08/08/29

(30)

Job Completion



Handwritten signature
08.08.29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 41352 |
| Description: Swing Arm | | Part Number: D3447-9 |
| Inspection Dwg: D3447 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 8.02 | +/-0.030 | 8.016 | ✓ | | | |
| 7.075 | +/-0.005 | 7.074 | ✓ | | | |
| R0.38 | +/-0.030 | R0.380 | ✓ | | | |
| Ø0.375 | +0.006/-0.001 | Ø0.380 | ✓ | | | |
| 0.75 | +/-0.030 | 0.750 | ✓ | | | |
| 0.375 | +/-0.005 | 0.376 | ✓ | | | |
| 0.470 | +/-0.005 | 0.4725 | ✓ | | | |
| 1.100 | +/-0.010 | 1.103 | ✓ | | | |
| 0.71 | +/-0.030 | .708 | ✓ | | | |
| 0.178 | +/-0.010 | .179 | ✓ | | | |
| 1.825 | +/-0.010 | 1.821 | ✓ | | | |
| 2.375 | +/-0.010 | 2.376 | ✓ | | | |
| R0.25 | +/-0.030 | R0.250 | ✓ | | | |
| R0.13 | +/-0.030 | R0.130 | ✓ | | | |
| 3.700 | +/-0.010 | 3.700 | ✓ | | | |
| 0.25 | +/-0.030 | 0.250 | ✓ | | | |
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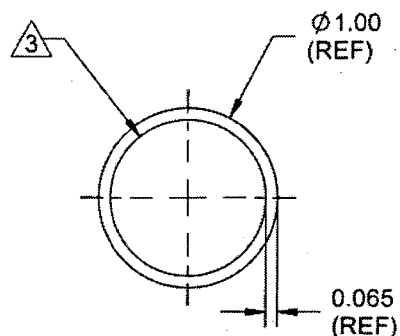
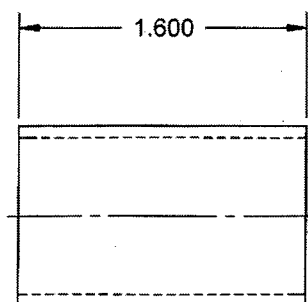
| | | | |
|------------------|-------------------------|---------------------|-----|
| Measured by: N.A | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 08/08/26 | Date: 08/08/27 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------|-------------|
| A | 08.07.24 | New Issue | KJ/DD [Signature] | [Signature] |



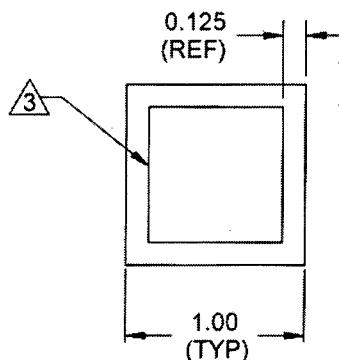
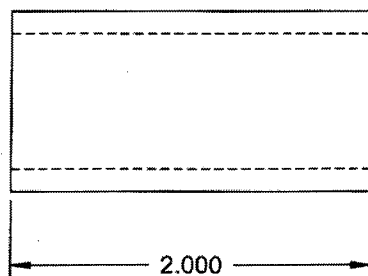
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| CHECKED 3 | APPROVED 3 | DRAWING NO. D3447 | REV. A SHEET 1 OF 4 |
| DATE 05.07.19 | | TITLE BLADE FOLD KIT PARTS | SCALE 1:1 |
| A | 05.07.19 | NEW ISSUE | |

RELEASED
05/08/18



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

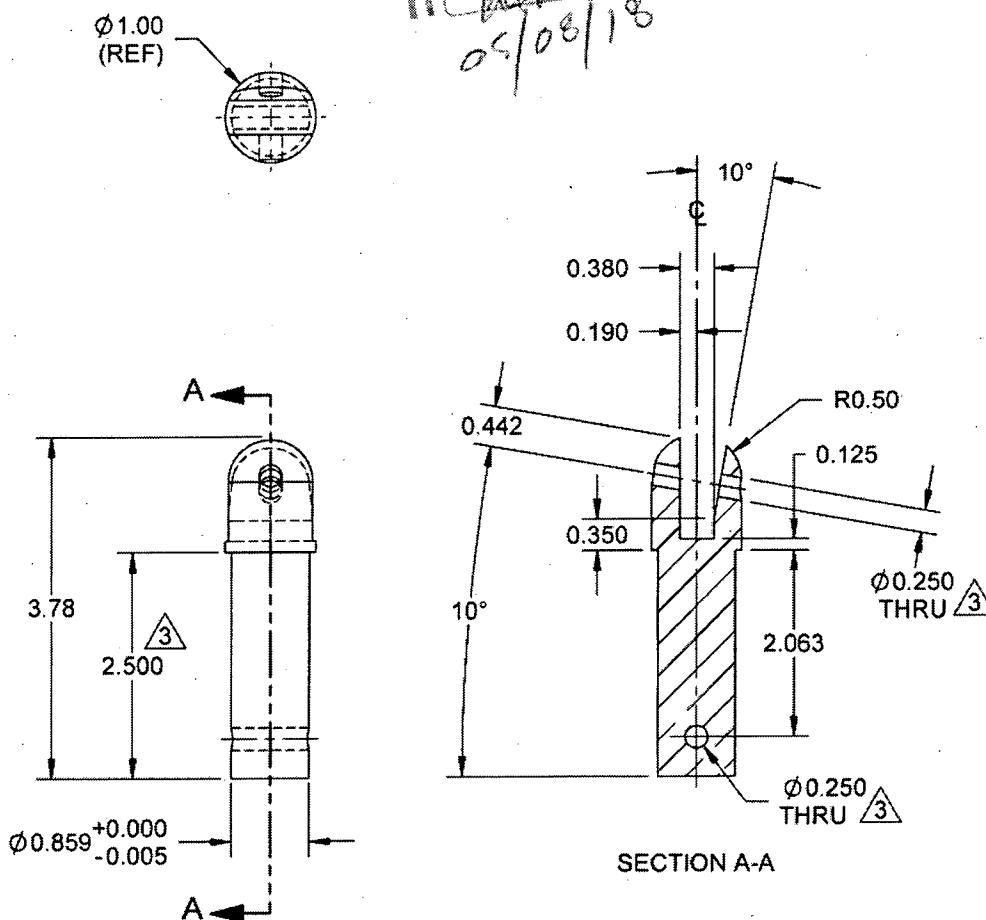
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| DATE 05.07.19 | | TITLE BLADE FOLD KIT PARTS | SCALE 1:2 |



D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99


NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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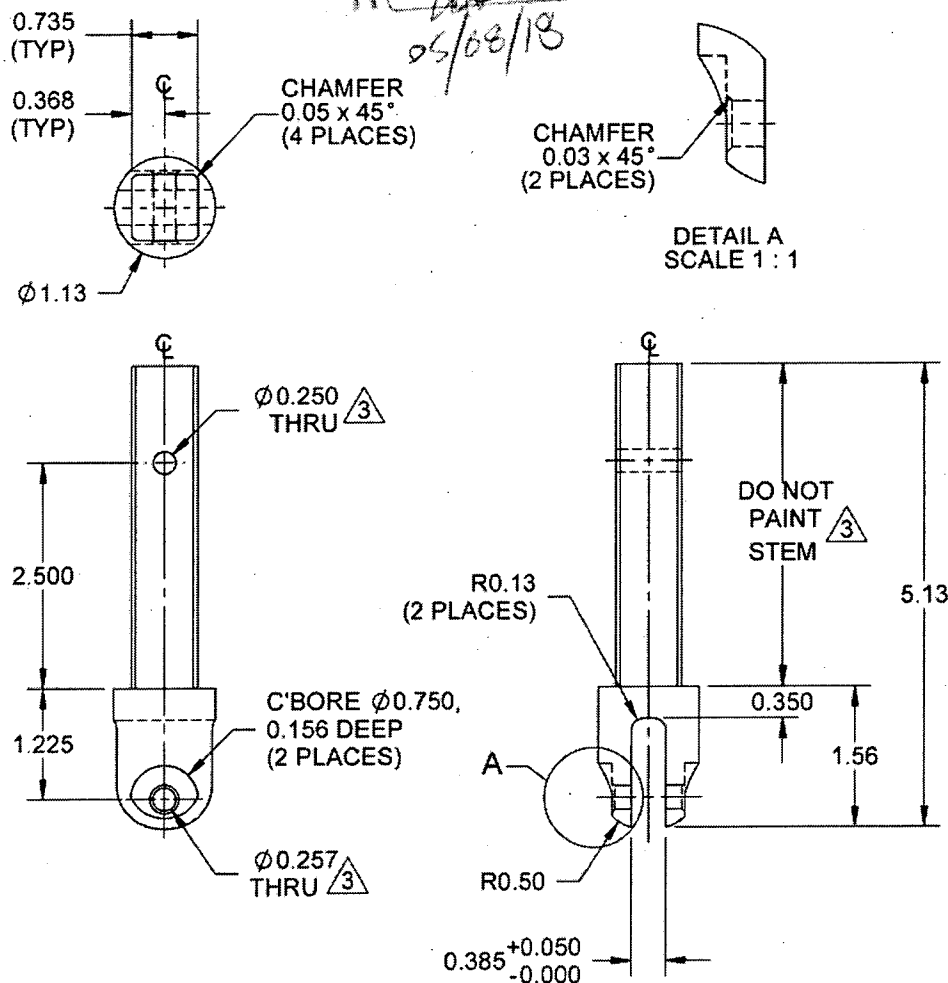
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| DATE 05.07.19 | | TITLE BLADE FOLD KIT PARTS | SCALE 1:2 |

RELEASED

05/08/18



D3447-7 CLEVIS

SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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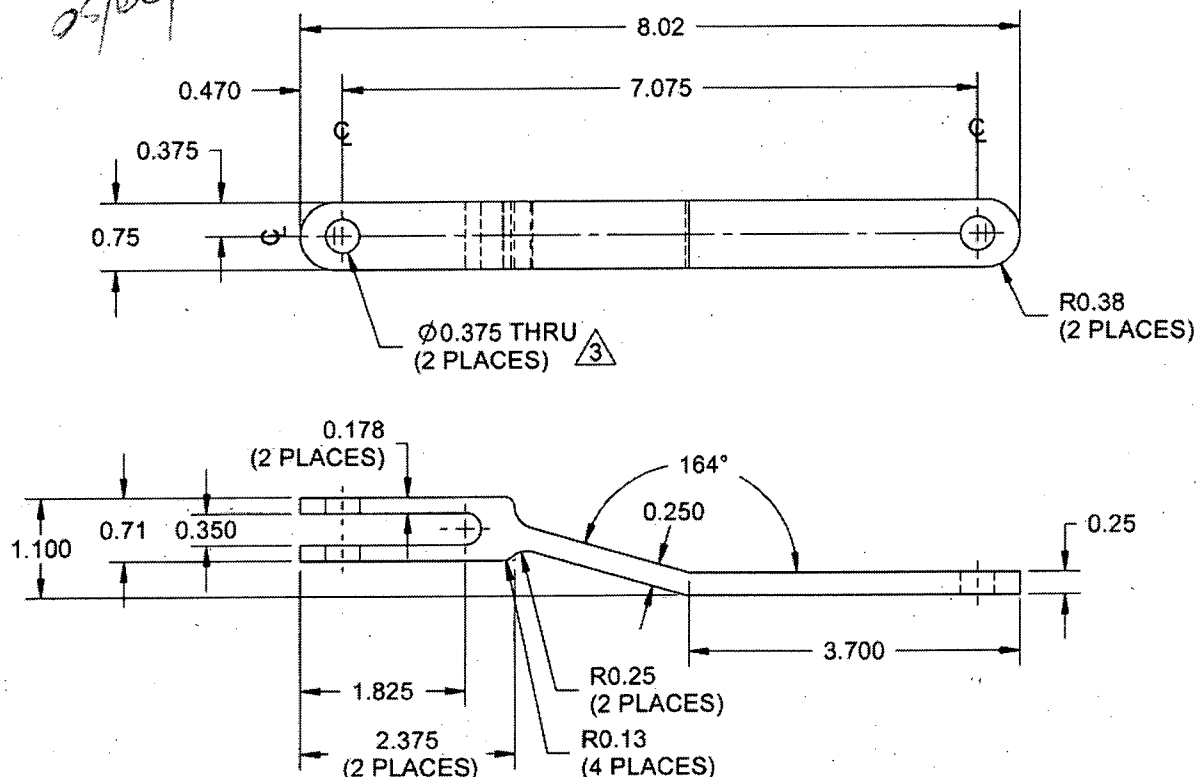
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| DATE 05.07.19 | | TITLE BLADE FOLD KIT PARTS | SCALE 1:2 |

RELEASED
[Signature]
05/08/18



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1 SUBJECT TO AMENDMENT
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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